

Push

Work Order ID 137596

137596

Page 1

Tuesday, October 27, 2015 8:48:17 AM

Item ID: D3259-5 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Spacer
Start Date: 10/7/2015 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 10/7/2015 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: MLS Date: OCT 27 2015 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3259	Rev B

100

0.02

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg D3259

Dwg Rev: B

Prog Rev: 15

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(4) _____ 02/15/10/28
(4) _____ 02/15/10/28

Work Order ID 137596

Tuesday, October 27, 2015 8:48:18 AM

137596

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Item ID: D3259-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 10/7/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/7/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00				4	FF	OCT 28 2015	
Packaging	LOCATION : GA								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.01				MCS		OCT 28 2015	
Quality Control									

SA 151029

Picklist Print

Tuesday, October 27, 2015 8:48:22 AM

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Work Order ID: 137596

137596

Parent Item: D3259-5

D3259-5

Parent Item Name: Spacer

Start Date: 10/7/2015

Required Date: 10/7/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	181.5000	1.388	5.844210			
M2024T3S 032										**		0215/10/28	
2024-T3 .032 sheet													

Location	Loc Qty	Loc Code
MAT022	181.5	
M130497	8.5	
M132875	77	5
M133452	96	

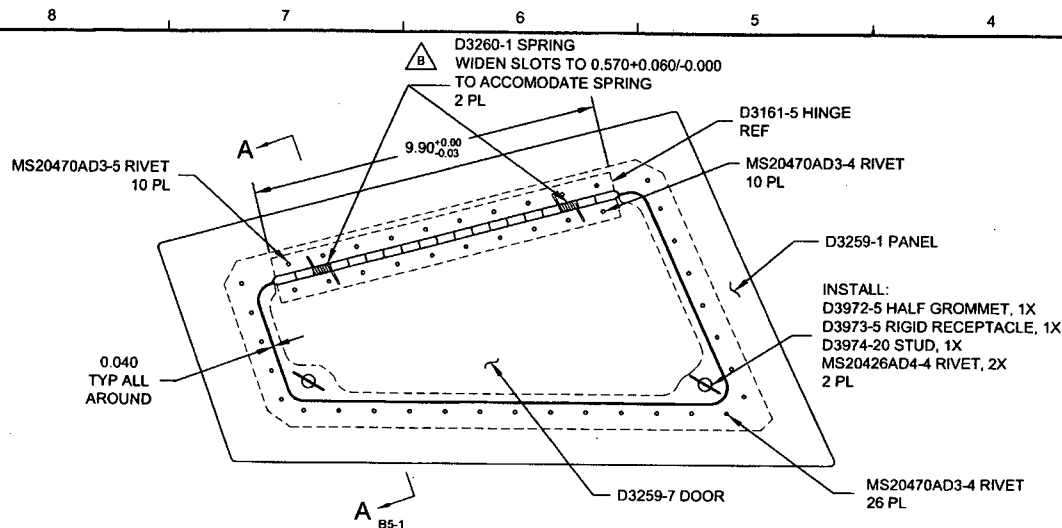
DART AEROSPACE LTD		Work Order: 137596
Description: Spacer		Part Number: D3259-5
Inspection Dwg: D3259	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

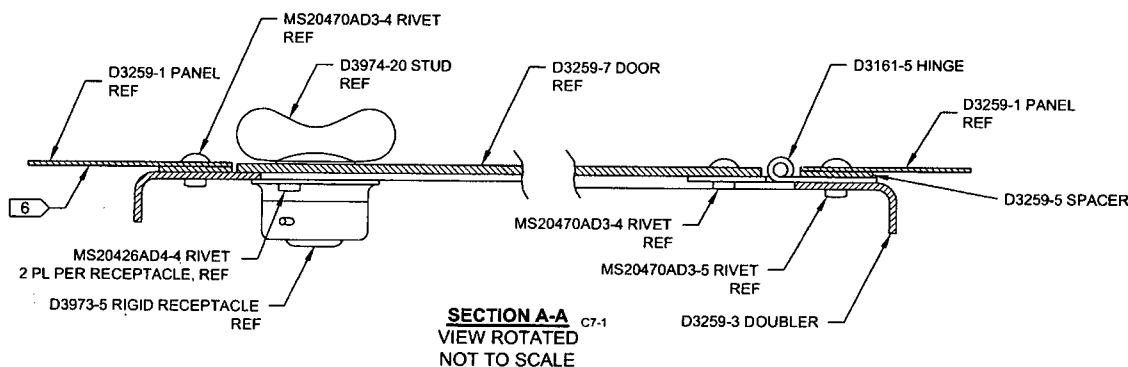
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	9.005	/		V=PL-02	
1.000	+/-0.005	1.001	/		V=PL-01	
5.000	+/-0.005	4.998	/		Tap	
12.000	+/-0.005	12.004	/			
3.5000	+/-0.005	3.500	/			
0.875	+/-0.005	.874	/			
0.260	+/-0.010	.263	/			
R0.50	+/-0.030	.50	/			
0.250	+/-0.010	.254	/			
0.875	+/-0.005	.873	/			
Ø0.098	+0.005/-0.000	Ø.100	/			
0.550	+/-0.010	.556	/			
R0.50	+/-0.030	.50	/			
10.062	+/-0.010	10.062	/			
R0.13	+/-0.030	.13	/			
0.032 thick	+/-0.010	.032	/			
0.130	+/-0.010	.130	/			

Measured by: <i>DM</i>	Audited by: <i>DAS</i> <i>S8</i>	Preliminary Approval:
Date: 15/10/28	Date: OCT 28 2015	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	<i>MA</i>



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-041	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-3	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF, DZUS
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



D3259-041 ACCESS PANEL ASSEMBLY

NOTES:

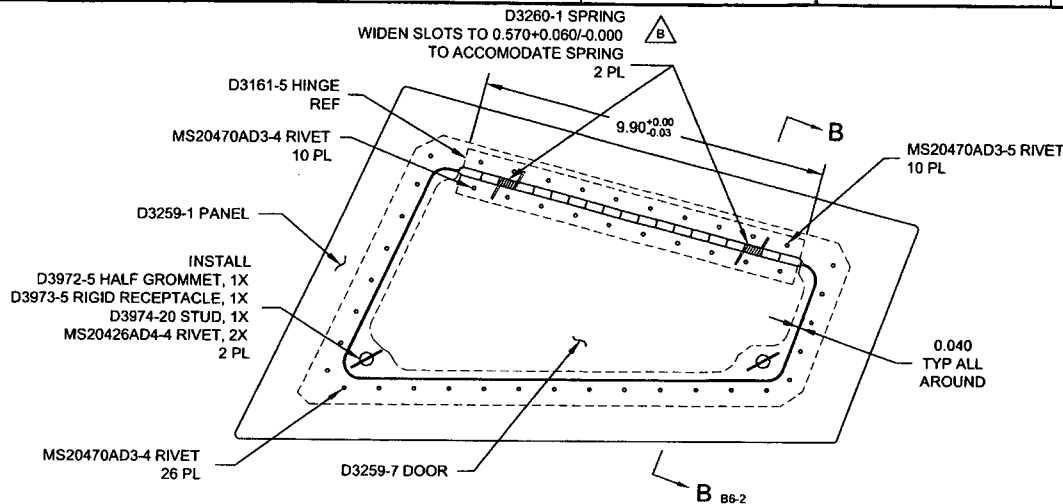
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137596 MJS
15-10-08

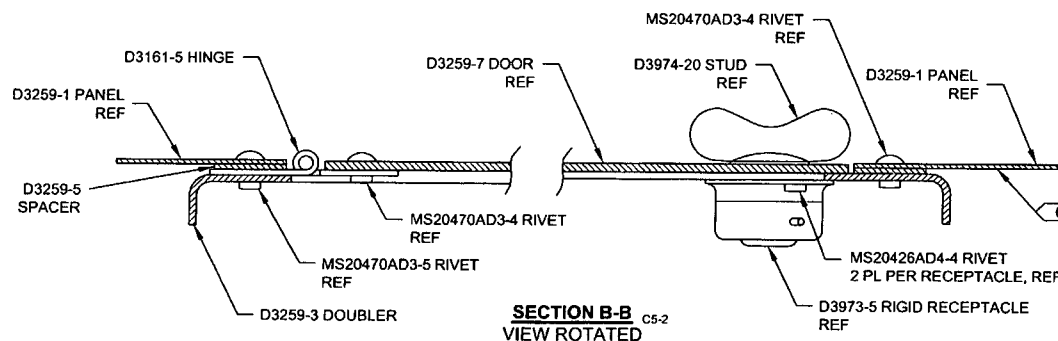
RELEASED
2009-10-08

B	REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5)	CP	09.08.12
A	-3F REDESIGN (SHT 6), WIDEN SLOTS (ZN D6-1, D5-2)	CP	04.02.25
REV.	NEW ISSUE	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3259	SHEET 1 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.08.12		

8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



D3259-042 ACCESS PANEL ASSEMBLY

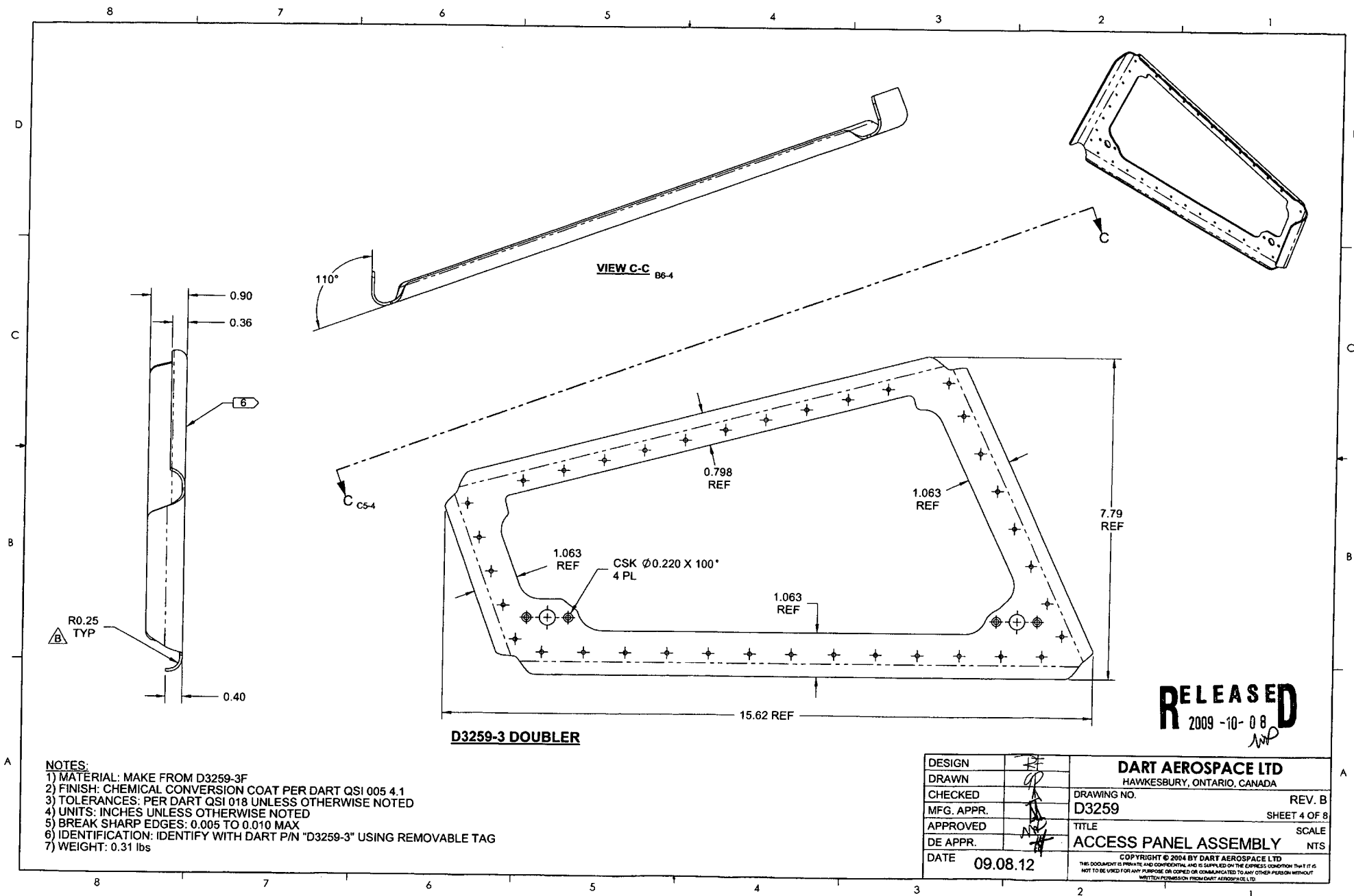
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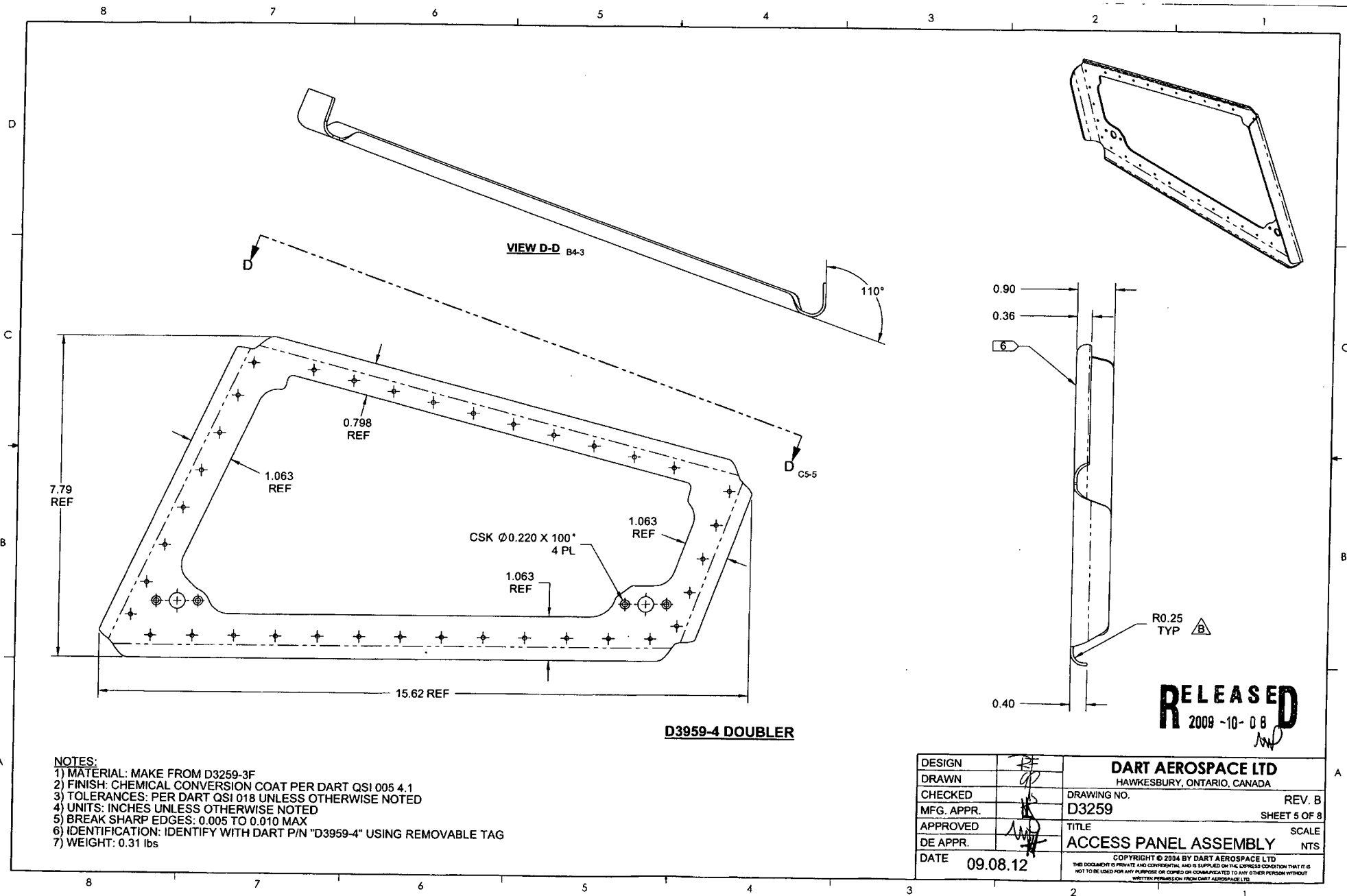
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

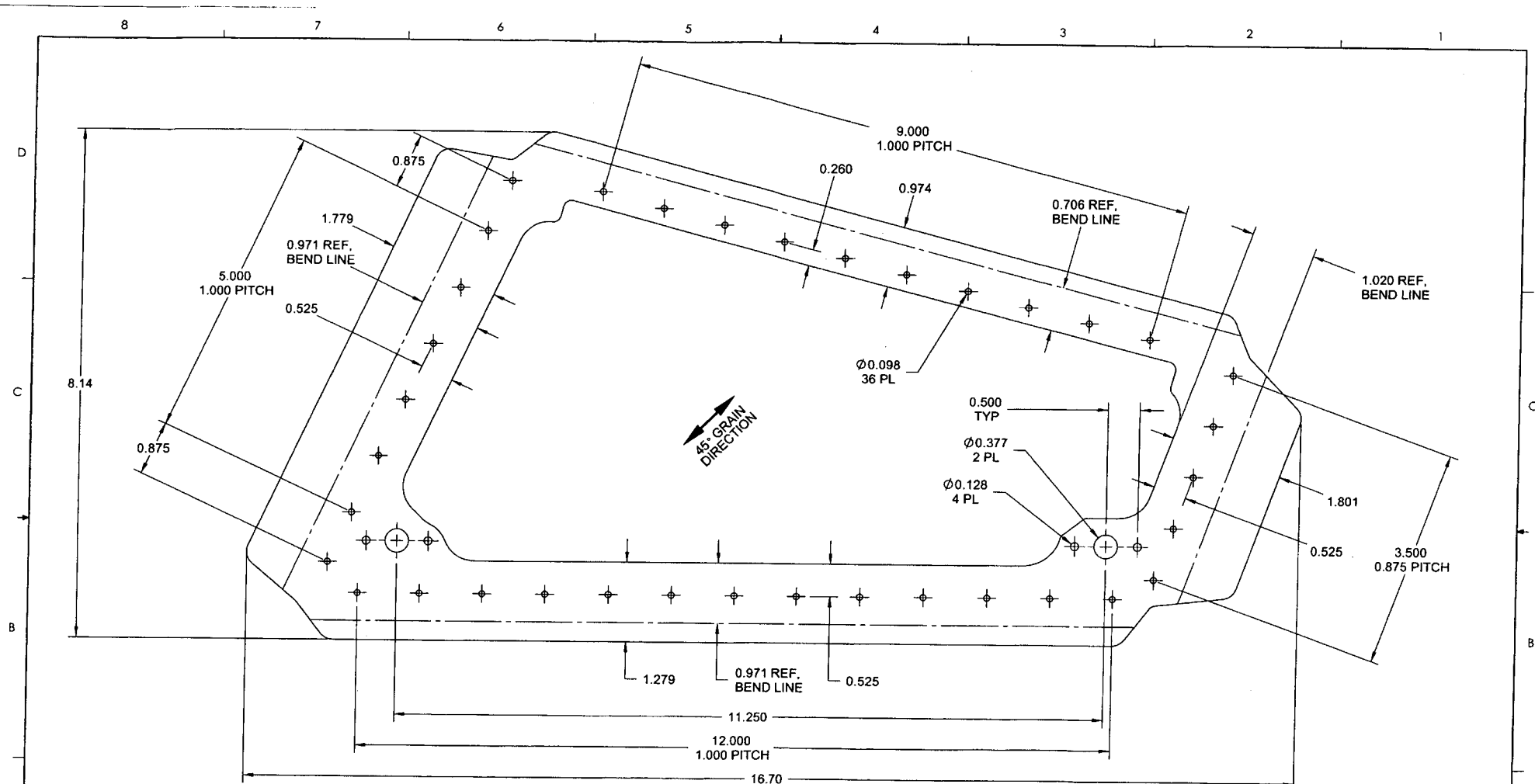
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2009-10-08

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3259	SHEET 2 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSEMBLY	NTS
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DATE	09.08.12		

8 7 6 5 4 3 2 1







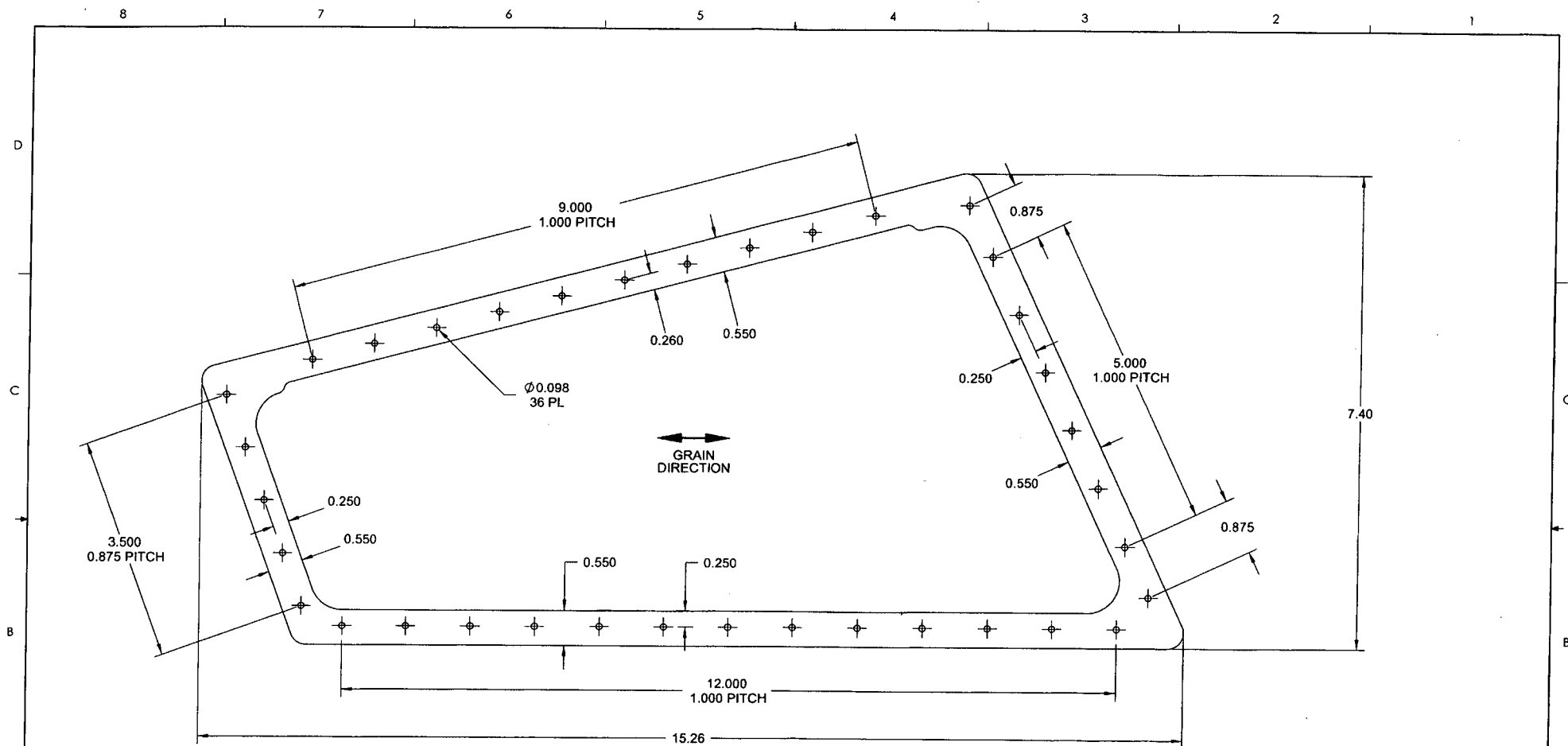
D3259-3F DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

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APPROVED		ACCESS PANEL ASSEMBLY	SCALE
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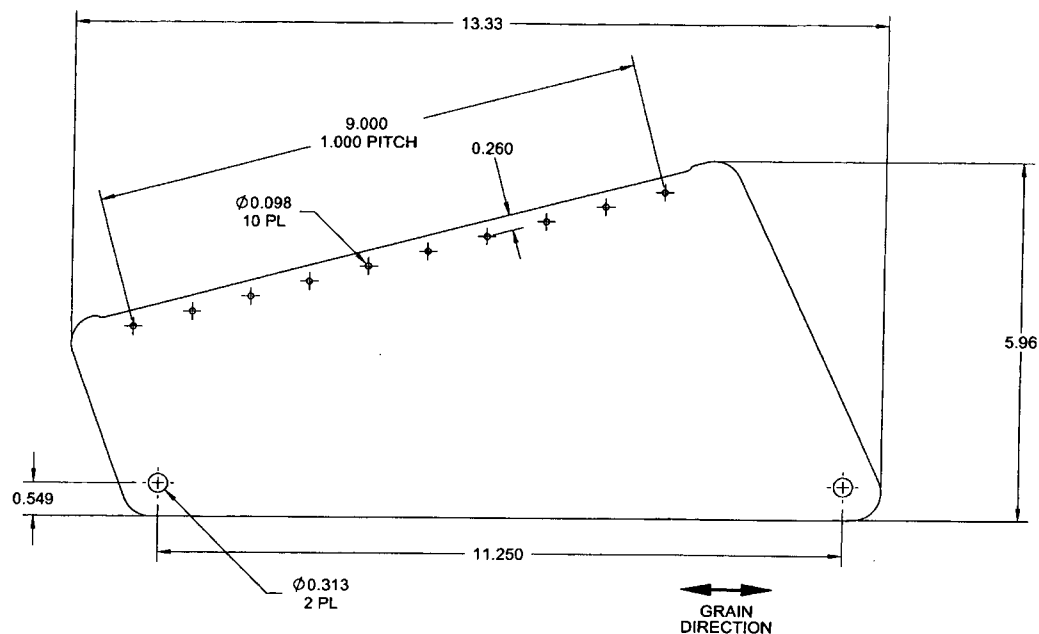
D3259-5 SPACER

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
- 7) WEIGHT: 0.07 lbs
- 8) MAKE PER DWG FILE "D3259-5B.DXF"

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D3259-7 DOOR

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

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MFG. APPR.		D3259	SHEET 8 OF 8
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